

Date: Tuesday, 11/21/2006 1:15:19 PM
User: Kim Johnston

Process Sheet

SPLIT

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 29601		
Estimate Number	: 10256		
P.O. Number	: <i>NIA</i>	Part Number	: D22303
This Issue	: 11/21/2006 S.O. No. : <i>NIA</i>	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>NIA</i> Type : MACHINED PARTS	Drawing Revision	: F
Previous Run	: 28245	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/5/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	300 Um: Each
Comment	: Est D 06.05.18 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D2423	Lug Extrusion
Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s) Lug Extrusion D2423 Batch: <i>23779</i> <i>2.6</i> <i>06/11/24</i> <i>300</i>		
2.0	BAND SAW	BAND SAW
Comment: Band Saw Cut D2423 extrusion to 0.82" Batch: <i>23779</i> <i>2.6</i> <i>06/11/24</i> <i>300</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<i>PG</i> <i>Issue 1.0 2593</i> <i>06/11/24 (300)</i> Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. <i>Machine per drawing D2230 Rev. F</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<i>PG</i> <i>Receive & inspect for transit damage 12/10/11</i> Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC5	SECOND CHECK
Comment: SECOND CHECK <i>inspect level 5</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 2P Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MOUNTING LUG

Job Number: 29601

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51371

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



C20710112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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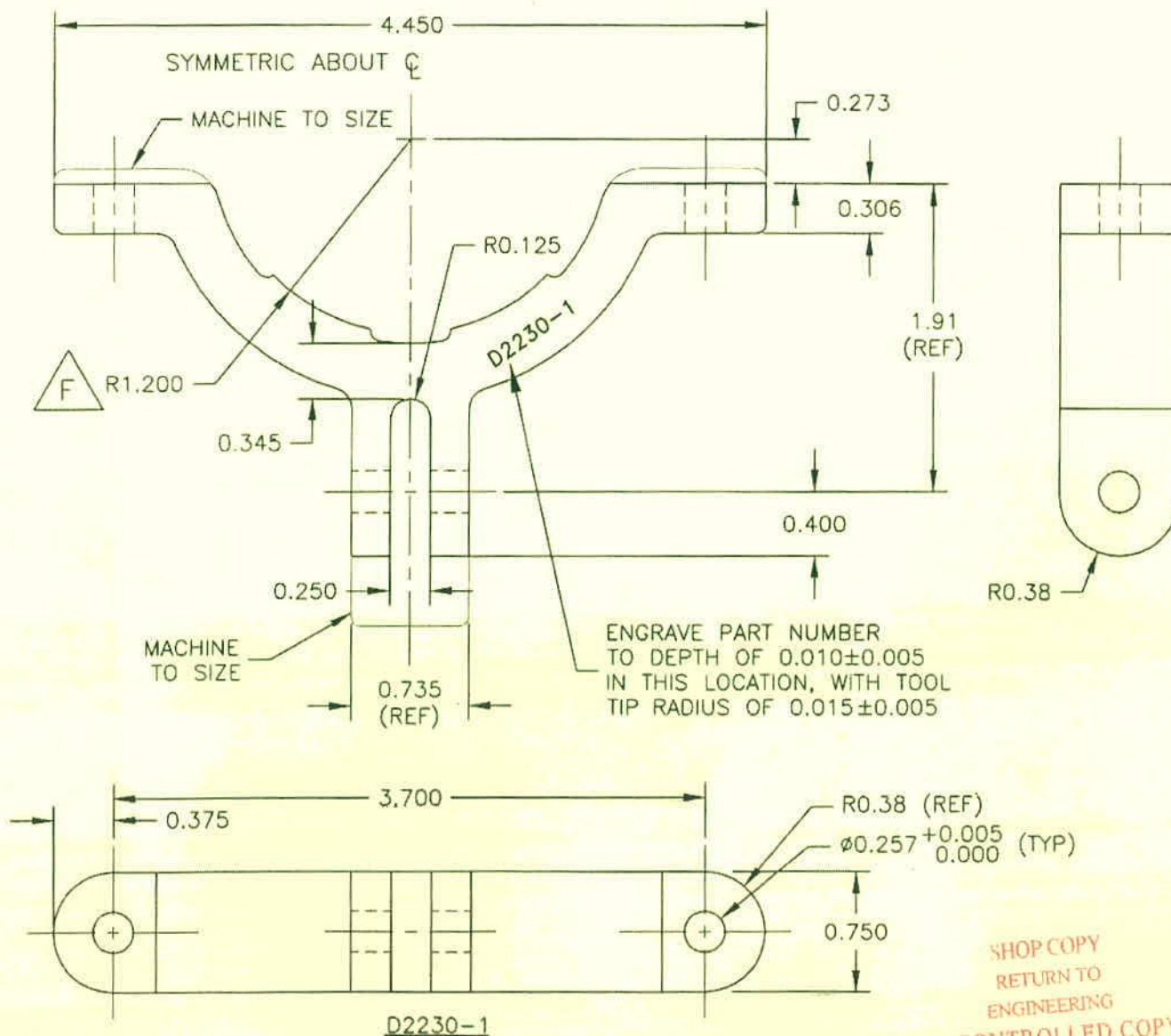
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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED
99.12.21 PS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29601

1871
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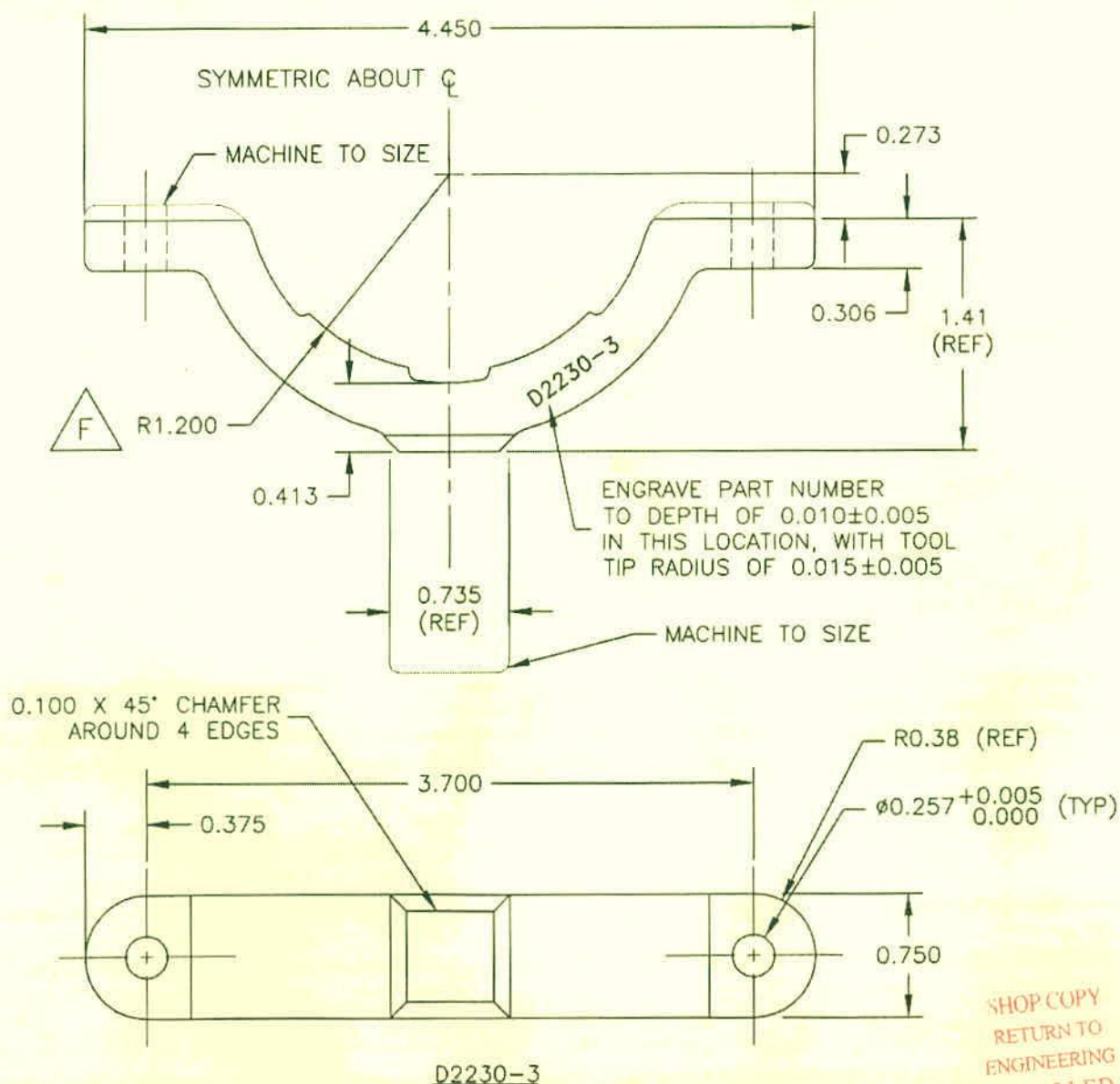
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Feb 1st



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
79.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29601



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

69

D2230-3

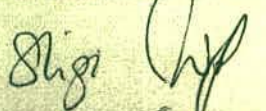
Lug B29601

2593

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, January 11, 2007

